

85644

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/12/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/26/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: MF

Date: 12-06-12 Tooling:

Date:

Run Start *NR1*

QC:

Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

**Insp.
Stamp**

Revision Nbr

D4018

C

100

Weld per dwg A/R S.S. rod Batch: 11/8/61 0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

110

QC9- Inspect visual per QSI004- Fusion Welds	0.00
--	------

110

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 85644

Tuesday, June 12, 2012 2:40:23 PM

85644

Page 2

Item ID: D4018-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Short Basket Lid Assembly (350)

Stop

NS2

Start Date: 6/12/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/26/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: 11:10

Oven Temperature: 320°F

Finish Time: 11:40

140

Wing Walk as per dwg QSI005 4.4 Batch 12613. 0.00

140

HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

Install placard and label as per dwg

***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

87644

1x Cpc 12.06.19

ML 12/06/19

M121279

1 12/06/19

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Work Order ID 85644***85644***

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Tuesday, June 12, 2012 2:40:23 PM

Item ID: D4018-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Short Basket Lid Assembly (350)

Stop ***NS2***Start Date: 6/12/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/26/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: **D4032-041** 0.00***160***

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

1 0 12-06-19.**MW 12/06/26****MF 12-06-20**

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 85644

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 6/12/2012

Required Date: 6/26/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC
as per dwg revC DD 10.08.18 verified by:EC IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4018-1 Rib		Manufactured	No			100	Each	10.0000	2	2		12.06.14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		10							
				72545		5							
				82281		5							
✓ D4018-3 Rib		Manufactured	No			100	Each	10.0000	2	2		12.06.14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				76380		8							
				WA005		2							
				73032		2							
✓ D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	19.0000	3	3		12.06.14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		19							
				83680		1							
				84777		18							
✓ D4018-5 Rib		Manufactured	No			100	Each	37.0000	6	6		12.06.14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		36							
				81178		36							
				WA005		1							
				80776		1							

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 85644

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 6/12/2012

Required Date: 6/26/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-041 Manufactured No

100 Each 17.0000

1

1

Lid Rib Assembly, Fwd (350 Basket)

Location

Loc Qty

Loc Code

WA

17

63720

0

82985

4

82986

13

✓ D4035-043 Manufactured No

100 Each 3.0000

Lid Rib Assembly, Aft (350 Basket)

Location

Loc Qty

Loc Code

WA

2

81452

1

82987

1

WA006

1

81202

1

✓ D2581 Manufactured No

100 Each 47.0000

2

2

Mounting Bracket

Location

Loc Qty

Loc Code

WA

5

82506

2

83230

3

WA005

42

70766

2

81253

1

82897

39

✓ D4020-7 Manufactured No

100 Each 0.0000

Mesh (350 Basket Short, Lid)

✓ D4021-3 Manufactured No

100 Each 22.0000

Data Plate

Location

Loc Qty

Loc Code

WA

22

80897

9

82507

1

85358

12

Tuesday, June 12, 2012 2:40:23 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, June 12, 2012 2:40:23 PM

Page 3

Work Order ID: 85644

Parent Item: D4018-041

Start Date: 6/12/2012

Required Date: 6/26/2012

Parent Item Name: Short Basket Lid Assembly (350)

Start Qty: 1.00

Required Qty: 1.00

D2728-3 Manufactured No

140

Each

0.0000

1

1

Dart Logo label

15050.

BR 126-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

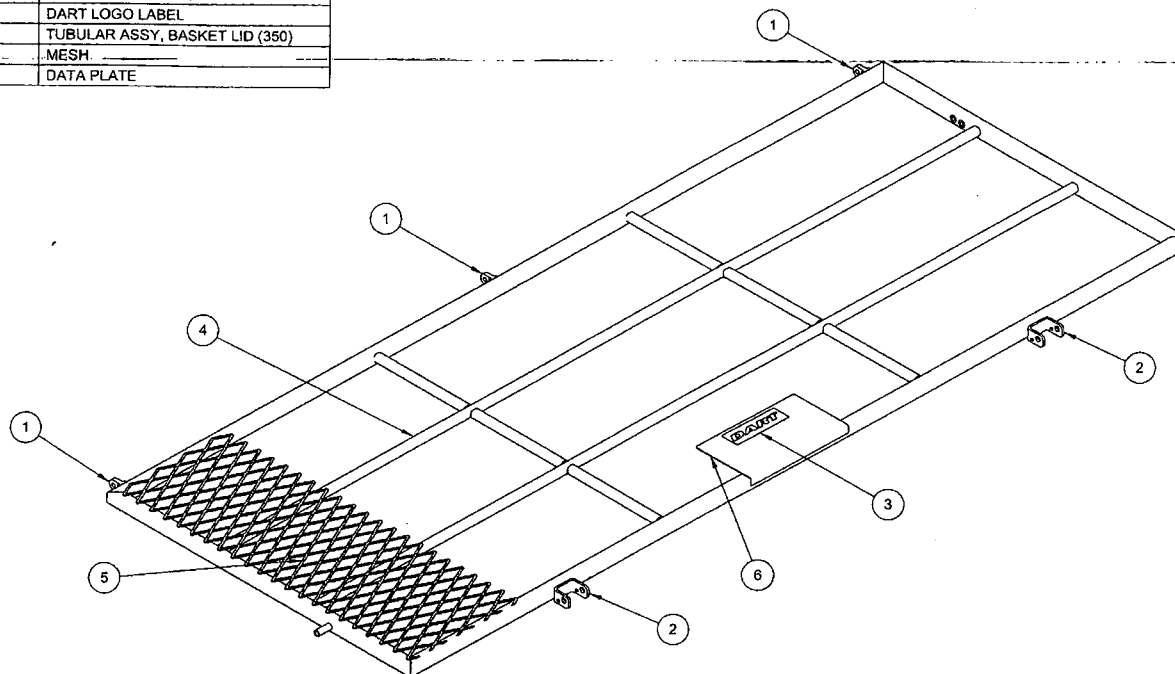
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.05
ECW 10-516

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	MS	D4018	SHEET 1 OF 4
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	SHORT BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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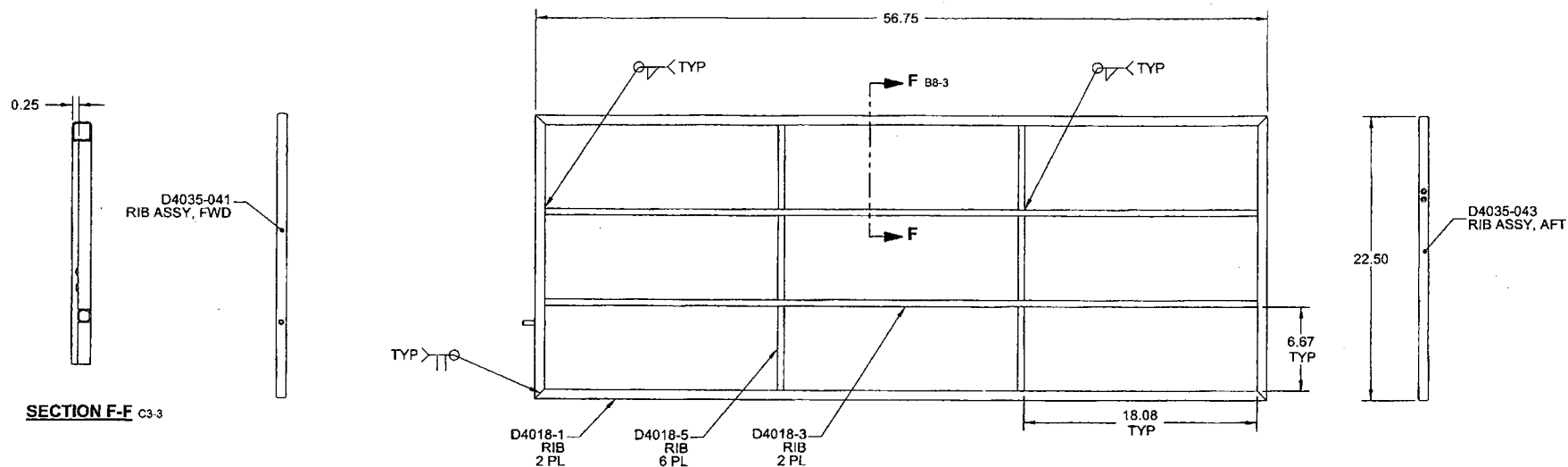
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D4018	REV. C
MFG. APPR.	MP	TITLE	SHEET 3 OF 4
APPROVED	MP	SHORT BASKET LID ASSY (350)	SCALE
DE APPR.	MP	NTS	
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY DISSEMINATION OF THIS DOCUMENT TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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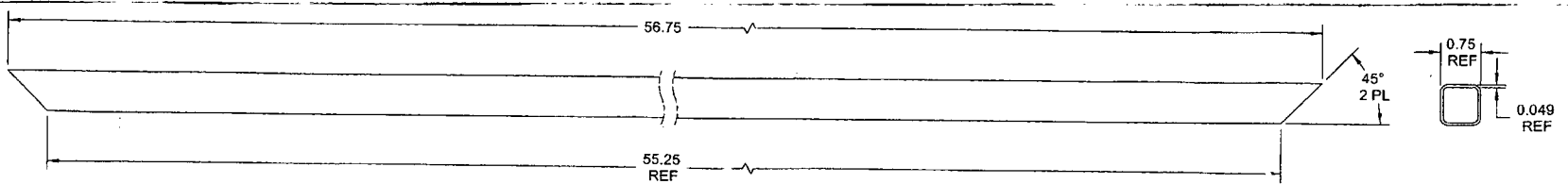
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8 7 6 5 4 3 2 1

D

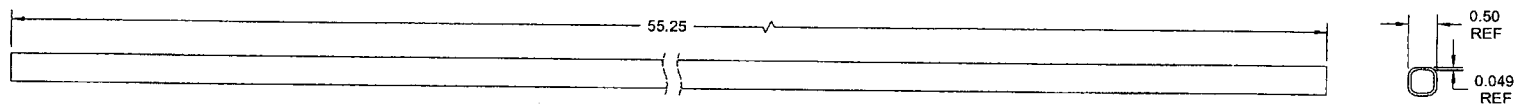
D



D4018-1 RIB

C

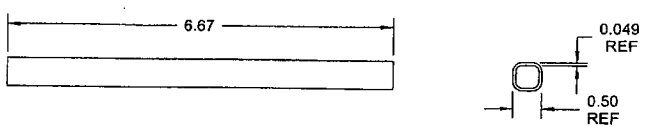
C



D4018-3 RIB

B

B



D4018-5 RIB

- NOTES:**
- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
 - 3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.05

A

A

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JSC	DRAWING NO. D4018	REV. C
MFG. APPR.		SHEET 4 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350) NTS	
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8 7 6 5 4 3 2 1

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